

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019137**Date Inspected:** 06-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (11AE)

This QA Inspector along with Mr. Manoj Prabhune photographed and documented at various locations on OBG 11AE prior to the shipment of (Voyage 7) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 11AE (Panel Point 95 thru Panel point 97.5) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 11AE – PP 95.5, 96.5 and PP 97.5.
2. Corner Assembly – Crossbeam side of segment 11AE – PP 95, 96 and PP 97.
3. Longitudinal Diaphragm - Crossbeam side of segment 11AE – PP 95, 96 and PP 97.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 11AE – PP 95, 96 and PP 97.
5. Sea fasteners- 11AE – PP 95, 96 and PP 97.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 11AE – PP 95, 96 and PP 97.
7. Longitudinal Diaphragm – Bike path side of segment 11AE – PP 95, 96 and PP 97.
8. Corner Assembly – Bike path side of segment 11AE – PP 95, 96 and PP 97.
9. Truss post – Bike path side of segment 11AE – PP 95.5, 96.5 and PP 97.5.

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This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (12AE and 12BE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) overhead position on side panel piece mark no. OBE12D. The location was the complete joint penetration groove weld joining the side panel of segment 12AE and 12BE at work point E4 to E6. The welder ID was 040320. The welding was performed against critical welding repair report B-CWR2681. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 003 in the (4G) overhead position on side panel piece mark no. OBE12D. The location was the complete joint penetration groove weld joining the side panel of segment 12AE and 12BE at work point E4 to E6. The welder ID was 040320. The welding was performed against critical welding repair report B-CWR2681. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (12AW and 12BW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 005 in the (4G) overhead position on edge and side panel piece mark no. CA3007. The location was the complete joint penetration groove weld joining the edge and side panel of segment 12AW at work point W1. The welder ID was 046709. The welding was performed against welding repair report B-WR18910. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on edge and side panel piece mark no. CA3008. The location was the complete joint penetration groove weld joining the edge and side panel of segment 12BW at work point W1. The welder ID was 046709. The welding was performed against welding repair report B-WR18910. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
